

Work Order ID 59140

Wednesday, May 26, 2010 3:10:41 PM



Page 1

Item ID: D2583

Accept



Setup Start



Revision ID:

Item Name: Latch Bracket

Stop



Start Date: 5/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 10-5-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2583

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2583 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-

Deburr if necessary

6052 .040

10-6-2



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-6-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subtotal

units
420

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE Memo Deburr Form on CNC Brake as per Dwg D2583	0.00 0.00				<u>20</u>			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>20</u>			
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>10</u>	<u>06</u>	<u>17</u>	<u>20</u>

Sp 10/06/16

Sub 16

contd
400

10 06 17 20

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Cust Item ID:

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:15

OVEN TEMPERATURE:

FINISH TIME: 9:45

20 10-6-22

170

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

10-6-22 sf 20x

180

Identify as per dwg & Stock Location

0.00

Packaging

Memo

0.00

Packaging

10-6-22 sf 30x

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Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/23 J

B10-6-22

20

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Picklist Print

Wednesday, May 26, 2010 3:10:48 PM

Page 1

Work Order ID: 59140



Parent Item: D2583



Parent Item Name: Latch Bracket

Start Date: 5/26/2010

Required Date: 6/4/2010

Comments: IPP: C□00.11.01□Removed P/O for Powder Coat- in house process□DM□
IPP: D□06.07.21 Waterjet EC

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Otv	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	82.0000	0.1169	2.461053			



5052-H32 .040 Sheet



PB 10-6-2

Location

Loc Qty

Loc Code

MAT

64

114488

64

MAT23

18

101875

2

109058

10

113123

6

113123

20

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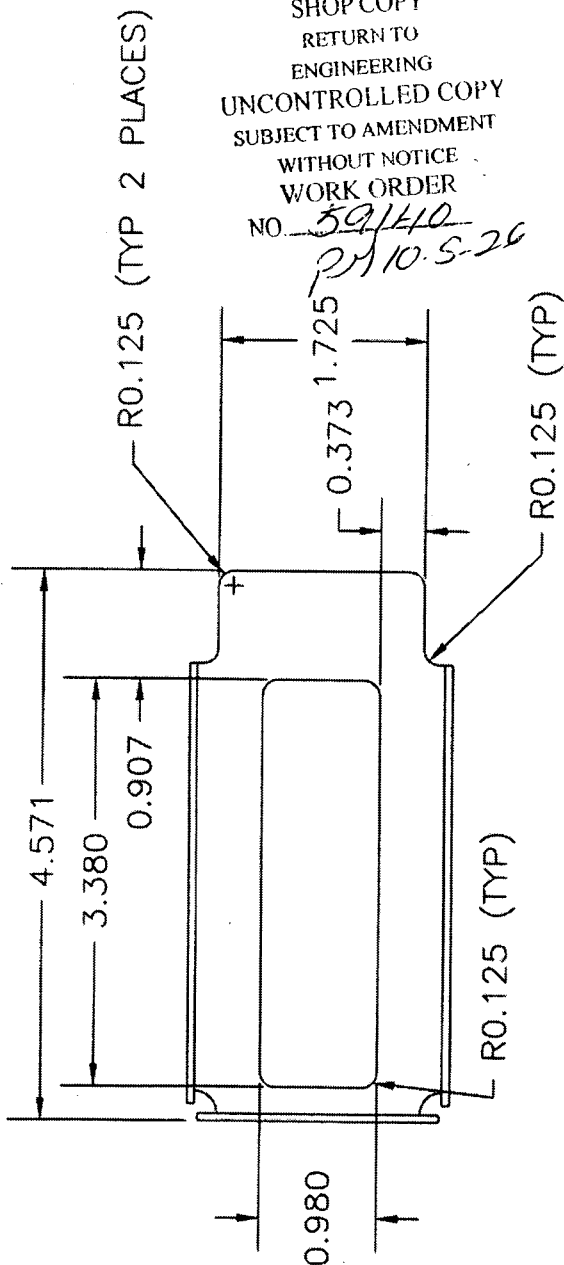
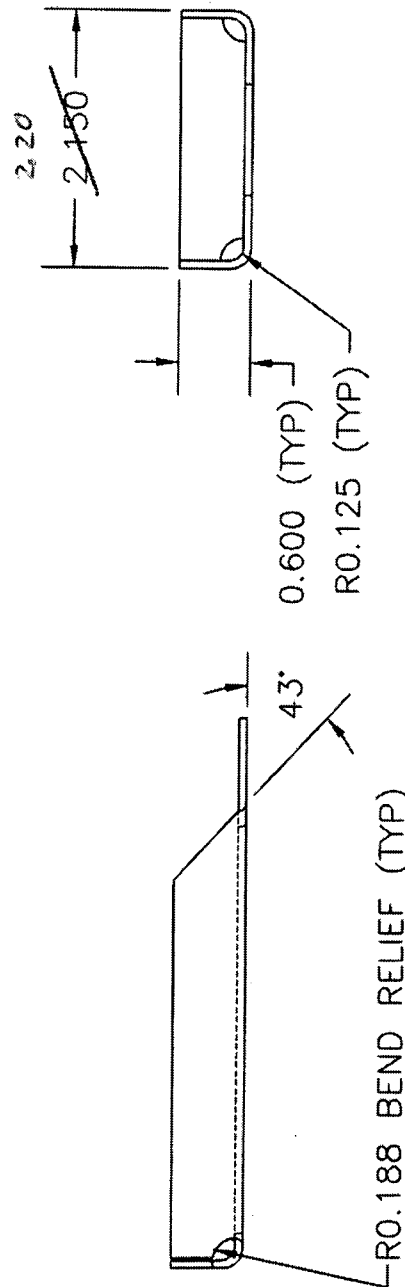
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DART**RELEASED**
KE 99.02.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *591410*
2110.5-26

*KE 99.02.26*

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN MIKE M.	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2583	REV. B SHEET 1 OF 1
DATE 99.02.22	TITLE LATCH BRACKET		SCALE 2:3
A	96.07.10	NEW ISSUE	
B	99.02.22	CHANGE OF FINISH (PER TSR A887)	

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